

Work Order ID 62878

Tuesday, October 12, 2010 1:04:50 PM

Page 1

Item ID: D117-762-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 10/12/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 10/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-10-12

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3582

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A

120

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Folio 3,
use bending aid DT9632
2- cut fwd end of tube as per dwg

> DP

10-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut Aft end using DT8185

2-Deburr ends

3-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

4-Locate DT 8973 & Drill Ground wire hole on top of Tube.

5-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

6-Drill pilot holes for wearplates using DT8974

7-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

8- open ground wear holes to 0.391" as per section B-B

9-Open Aft Cap holes using .209" drill.

10-Drill pilot holes for section D-D and E-E. Holes must be laid out by hand. Mark out Center line and make sure that 6.65 and 5.906 measurements are respected. Double check before drilling, do not open holes to finish size.

1 - BE 10/10/18

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Run Start




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Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  Skidtubes	Skidtubes	0.00				1		BE 10/10/19	
Skidtubes	Memo	0.00							
Skidtubes	1-Weld fwd cap D2964 per dwg D3582 and QSI004 A/R AL ROD Batch: m115778/m111385 2-Grind flush DP 10-10-26								
150  QC	QC10- Inspect visual per QSI004- ground welds	0.00				1			10/10/19
Quality Control	Memo	0.00							
160  QC	QC5- Inspect part completeness to step on W/O	0.00				1			10/10/19
Quality Control	Memo	0.00							

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Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

180

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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QC: Date: SPC (Y/N): Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1-Open X-Bolt holes to finish size as per Dwg D3582, all sections

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube, prep. tube for welding.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M 115114
Exp Date: 11/9/01

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M 115778

6-Grind welds flush

200



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

Signature: S 10/10/07

Stamp: (X)

Handwritten: DP 10-10-19

Handwritten: BB 10-10-20

Handwritten: DP 10-10-26

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Page 6

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Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

8/10/10/29

FD

215



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

0.00

Memo

P10-D
PR 10-10-28

220



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

Memo

START TIME 9:15
OVEN TEMPERATURE 320°
FINISH TIME: 9:45

1 PR 10-10-28

W/O: 62878		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-10-28		ADD D PRESS WASH SEQUENCE, BE ALLOWED. PERMANENT CHANGE. (DONE ON W/O 62879)	BT	10-10-28	1		

Part No: D117-762-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 7

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

QC3- Inspect Part Finish

0.00

⇒ 24

10/10/28



QC

Memo

0.00

Quality Control

1

0

240

HandFinishing

0.00



HandFinish

Memo

0.00

⇒ 24

10/10/28

Hand Finishing

Install Wearplate & Ground Wire inserts as per Dwg D3582.

1

0

W/O:		WORK ORDER CHANGES					
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Page 8

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250



HandFinish

Hand Finishing

HandFinishing

Memo

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: 11115114

Exp Date: 11/01

3-Install Wearplates as per Dwg D3582,

Note:Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: 11115114

Exp Date: 11/01

4-assemble o'ring as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 11104189

5- Wing Walk as per Dwg D3043 and QSI 005 4.4 = 11115790

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

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Tuesday, October 12, 2010 1:04:50 PM

Page 9

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270  Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D117-762-041 Location: _____ PPP Rev: _____	0.00 0.00		62878		10/11/12			
280  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/11/12 MEF 10-11-11

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Tuesday, October 12, 2010 1:04:54 PM

Page 1

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Parent Item Name: Replacement Skidtube





Start Date: 10/12/2010

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Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 07.06.11 New Issue EC
IPP Rev:B 08-02-22 change to revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																																																								
D2962-150  3.540 Outer Tube, Extrut		Manufactured	No				Each	100.0000	1	1																																																											
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D2971  Cross Bolt Spacer		Manufactured	No			190	Each	27.0000	1	1																																																											
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D3584-1  Web		Manufactured	No			190	Each	0.0000	1	1																																																											
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② DP 10-10-18

BE 10-10-19

BE 10/10/25
BB 10/10/20

3 62884

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Tuesday, October 12, 2010 1:04:54 PM

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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

D2973 Manufactured No 190 Each 162.0000 2 2



Cross Bolt Spacer



Location Loc Qty Loc Code

LG 162
14636 162

D3662-3 Manufactured No 190 Each 27.0000 1 1



Crossbolt Spacer



Location Loc Qty Loc Code

LG 27
44456 27

D3662-1 Manufactured No 190 Each 19.0000 3 3



Crossbolt Spacer



Location Loc Qty Loc Code

LG 19
55328 19

ALS4-1032-130 Purchased No 240 Each 1,047.000 36 36



Insert



Location Loc Qty Loc Code

PKG11 998
114723 998
ST282 10
110511 10
ST381 39
114654 39

1115911

x36

Tuesday, October 12, 2010 1:04:54 PM

Shop Packet Print

Page 2

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Tuesday, October 12, 2010 1:04:54 PM

Page 3

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Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

ALS4-428-165

Purchased

No

240

Each

107.0000

2

2



21 10/10/28

Inserts

Location

Loc Qty

Loc Code

FP

7

6989

7

ST282

100

114172

100

X2

D2965

Manufactured

No

250

Each

42.0000

1



11 10/10/28

Cap, 105 Skidtube

Location

Loc Qty

Loc Code

FP4

42

52057

42

X1

D3508-3

Manufactured

No

250

Each

2.0000

1



11 10/10/28

Wearplate

Location

Loc Qty

Loc Code

FP

1

38527

1

FP21

1

55339

1

362882

X1

D3508-9

Manufactured

No

250

Each

4.0000

1



11 10/10/28

Wearplate

Location

Loc Qty

Loc Code

FP21

4

54580

4

Y1

Tuesday, October 12, 2010 1:04:54 PM

Shop Packet Print

Page 3

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Start Date: 10/12/2010



Required Date: 10/22/2010

Start Qty: 1.00



Required Qty: 1.00

D3558-3	Manufactured	No	250	Each	13.0000	1	1
							<u>HL 10/10/28</u>
Gasket							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	13	
42253	1	
55468	12	

D3558-9	Manufactured	No	250	Each	18.0000	1	1
							<u>HL 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	18	
50928	4	
55469	14	

D3558-11	Manufactured	No	250	Each	3.0000	1	1
							<u>HL 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	3	
42254	3	

D3558-13	Manufactured	No	250	Each	35.0000	1	1
							<u>HL 10/10/28</u>
Gasket							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	35	
55467	1	
59558	34	

Tuesday, October 12, 2010 1:04:54 PM

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, October 12, 2010 1:04:54 PM



TABLE 1. *Continued*

Required Qty: 1.00



Wearplate

22/10/20

12

54644

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Wearplate

Loc Code

FP

3

54645

3

54.0000 2



Plug Assembly

Loc Code

FP013

54

44633

4

55622

50

29.0000

[illegible]

Plug Assembly

Loc Code

FP011

29

55621

29

19.0000

Figure 1

Plug Assembly

Loc Code

FP

19

54641

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 1:04:54 PM

Page 6

Work Order ID: 62878

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased No

250

Each

0.0000

2

2



1114348



x2 10/10/28

Washer

AN3C4A Purchased No

250

Each

1,511.000

28

28



10/10/28

BOLT

Location

Loc Qty

Loc Code

ST245

20

110139

20

ST303

3

115438

3

ST350

1488

114108

14

114416

12

114523

2

115300

460

115589

1000

x28

AN3C5A Purchased No

250

Each

1,169.000

2

2



10/10/28

Bolt

Location

Loc Qty

Loc Code

ST350

1159

114330

11

115015

16

115371

100

115422

100

115594

432

115835

500

x2

ST351

10

113121

10

Tuesday, October 12, 2010 1:04:54 PM

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 1:04:54 PM

Page 7

Work Order ID: 62878

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L NAS1149D0416J Purchased No

250

Each

223.0000

2

2



Washer



2
10/10/28

Location

Loc Qty

Loc Code

ST346

223

106785

2

110153

221

X2

AN960C10L NAS1149C0332 Purchased No

250

Each

29.0000

28

28



washer

1115832



x28 10/10/28

Location

Loc Qty

Loc Code

ST245

29

107534

29

AN4-4A Purchased No

250

Each

186.0000

2

2



Bolt



2
10/10/28

Location

Loc Qty

Loc Code

ST356

183

114615

183

ST361

3

108138

2

111295

1

NAS1611-012 Purchased No

250

Each

110.0000

6

6



O-RING



6
10/10/28

Location

Loc Qty

Loc Code

FP

110

108673

9

113845

101

X6

Tuesday, October 12, 2010 1:04:54 PM

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Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, October 12, 2010 1:04:54 PM

Page 8

Work Order ID: 62878

Parent Item: D117-762-041

Parent Item Name: Replacement Skidtube

Start Date: 10/12/2010

Required Date: 10/22/2010

Start Qty: 1.00

Required Qty: 1.00

NAS1611-015

Purchased

No

250

Each

25.0000

2

2



O-RING



10/16/28

Location

Loc Qty

Loc Code

FP

25

107178

5

115101

20

x2

NAS1611-016

Purchased

No

250

Each

109.0000

2

2



O-RING



10/16/28

Location

Loc Qty

Loc Code

FP

109

107178

9

112492

50

113524

50

x2

Tuesday, October 12, 2010 1:04:54 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

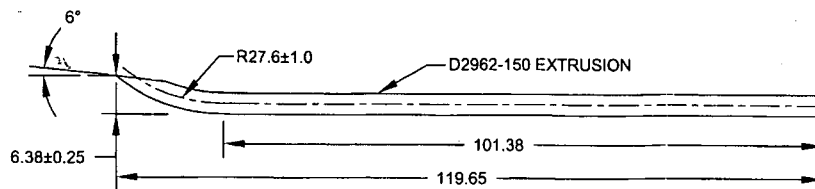
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

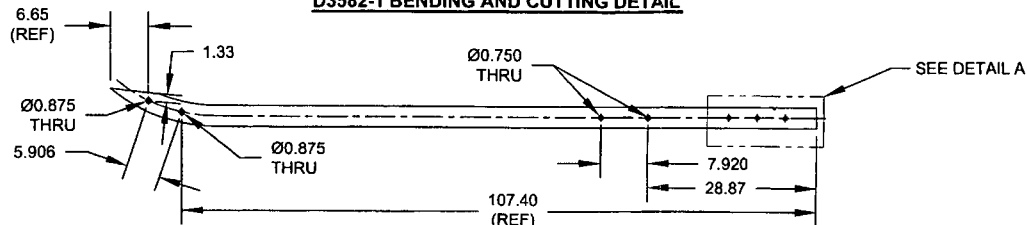
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

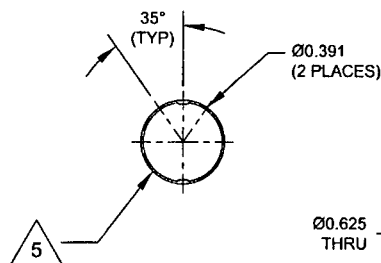
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004.
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



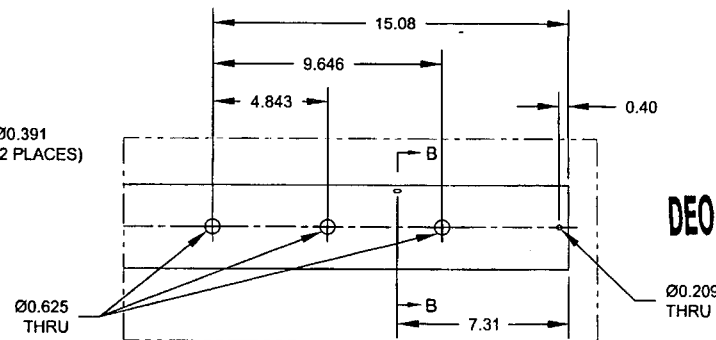
D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5



DETAIL A
SCALE 1:5

DEO ATTACHED

RELEASED
07.11.22

SHOP COPY
B-10-10-12
UNCONTROLLED COPY
SUBJECT TO V.I.S.
NO. 02878

REV.	NEW ISSUE	DESCRIPTION	PH	07.06.08
DESIGN	PH	DART AEROSPACE USA, INC	BY	DATE
DRAWN	PH	PORT HADLOCK, WA		
CHECKED	PH	DRAWING NO.		REV. A
MFG. APPR.	PH	D3582		SHEET 1 OF 2
APPROVED	PH	TITLE		SCALE
DE APPR.	PH	BK 117 SKIDTUBE ASSEMBLY		1:20
DATE	07.06.08	COPYRIGHT © 2001 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

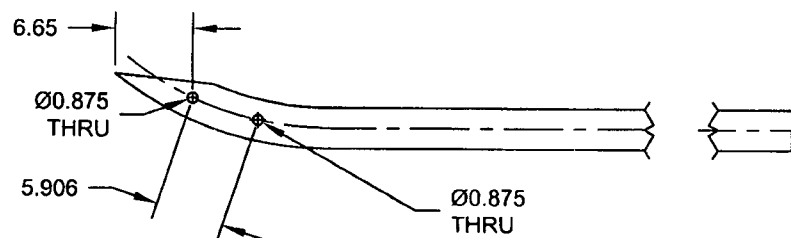
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

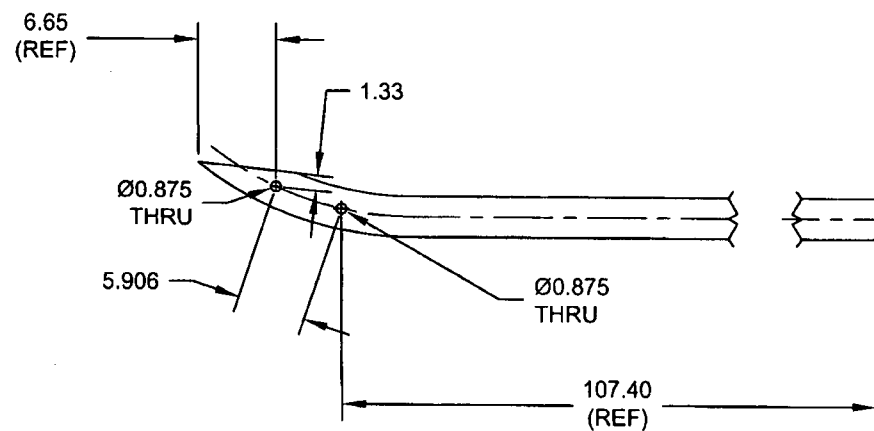
DRAWING NO. D3582	TITLE BK 117 SKIDTUBE ASSEMBLY	REV. A	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3582-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>PH</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 09.04.06	DATE 04.04.06	DATE 09.04.06	DATE 09/04/06		DATE 09.04.06		

FOR EASE OF MANUFACTURE AND TO ENSURE THE FIT OF BRISTOL WIRESTRIKE SKID GEAR DEFLECTOR:
UPDATE DIMENSIONING OF 2 FWD HOLES ON SHEET 1 AS SHOWN

IS:



WAS:



W/0 62878

RELEASED
09/04/22 *[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 220

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 54161
Part number: D17-762-041
Description: 17 sk.d tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P.D. Date of Test Coupon 09.12.10
Welder Barclay Elliott Date of Test Coupon 09/12/10

The above named individual is qualified in accordance with AWS D17.1.2001 to weld